Work Orde July 18, 2012-11		53	V VVVVI	<i>*</i> 871	53*						Page
Revision ID:	D350-588-04 Aft Door Assen			-Accept	*N900	<u>040</u>	100)* s	Setup Sta	1.7	S1*
	7/10/12	Start Qty: 1.00 Req'd Qty: 1.00	*1* *1*		Cust Item :	ID:				· "N	57
Approvals:	Process Plan	:: CX	Date: 12/07//2			ate:		F	Run Sta Sto	171	R1* R2*
Sequence ID/ Work Center ID	}	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr D2445/D350-5		sion Nbr		4	f e'i						
*100 *100* DC		DOCUMENT CONTRO	L luefile and create labels pe	0.00 0.00 0.00 D CI	5) 1)) \ HG003				MC	5 12	-11-
*110 *110* Purchasing	•	Supplier: De	D2445 Baggage Door	0.00				C	X 12	/07//8	? . ()

(1)





											DQA:	Date:	
NCR: Y	'es /	' No				WORK ORDER NON-C	ONF	ORN	MANCE / UP				
							-				QA Closed:	Date:	
Work Orde	er:					DISPOSITION				AGAINST DEI	PARTMENT	/PROCESS	
	··· —					Rework	1		Skid-tube	Crosstube		Water Jet	Engineering
Part N	lo.					Scrap			Machining	Small Fab	Pro	d. Eng. Coor.	Quality
	_					Use-as-is	TI		noforming	Finishing		re/Packaging	Other
NCR N	lo.					Work Order Update			Large Fab	Composite		Supplier	
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Root					Descri	ption of work order update	Initi	al	Act	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chief	Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling										1.00			
Operator						· ·							
Material													
Setup													
Other		:											
Process													
Supplier													

	FAULT CATEGORY													
andin	g Gear		General						_					
	Bending		Bend		Grain		Ovalized		Pressure/Forced					
	Centre Not Concentric to O/S		BOM/Route		Hardware		Over/Under tolerance		Temperature/Cure					
L	Cracks		Broken/Damaged		Inspection Incomplete		Part Incorrect		Weld					
	Crushed/Crimped_		Burrs		Instructions Incomplete/Unclear		Part Lost/Missing		Wrong Stock Pulled					
	Cuffs		Contamination		Maintenance		Part Moved							
L	Heat Treat		Countersink		Mislabeled	L	Positioned Wrong		_					
	Inspection Strip in Tube		Cut Too Short		Misread		Power Loss/Surge	L	Other					
	Ripples in Bend		Drill Holes		Offset									
	Torque Waves in Extrusion		Drawing		Out of Calibration									
	Turning Sequence		Finish		Out of Sequence									
	Wave/Twist in Tube	Γ	Folio		Outside Dimensions									

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Training Unapproved

Small Fab

Small Fab

87153

Page 2

July 18, 2012 11:21:45 AM Setup Start D350-588-041 Accept Item ID: *N900040100* Revision ID: Stop Item Name: Aft Door Assembly Start Date: 7/10/12 Start Qty: 1.00 **Cust Item ID:** Required Date: 8/03/12 Req'd Qty: 1.00 **Customer:** Reference: Run Date: **Tooling:** Approvals: Process Plan: Date: Stop Date: SPC (Y/N): Date: Reject Sequence ID/ Tool ID Tool # Plan Accept Reject Insp. Operation Set Up/ Work Center ID Code Qty Qty Number Stamp Description Run Hours 0.00 120 Receive & Inspect for Damage & Mat'l Certs *120* Packaging 0.00 Memo Ensure Certificate of Conformity & Process Sheet are attached Packaging QC6- Inspect dimensions to drawing 130 *130* QC Memo Inspect as per Dwg D2445. Quality Control Audit process sheet. 0.00 140 Small Fab *140*

0.00

Assemble all of the above parts as per Dwg D350-588

Memo

12.16.13

									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	CONFORM	MANCE / UP		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap	r	Skid-tube Machining	Crosstube Small Fab		Water Jet d. Eng. Coor.	Engineering Quality
NCR No.					Use-as-is Work Order Update	Therm	noforming Large Fab	Finishing Composite	Rec/Sto	re/Packaging Supplier	Other
Root				Descri	ption of work order update	Initial	Ad	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data							-				
quip/Tooling											
Operator											
Material]										
etup											
Other											
Process											
Supplier											
raining											
Inapproved]										0

Landing Gear General Bend Grain Ovalized Pressure/Forced Bending BOM/Route Centre Not Concentric to O/S Over/Under tolerance Temperature/Cure Hardware Cracks Broken/Damaged Inspection Incomplete Part Incorrect Weld Crushed/Crimped. Burrs Instructions Incomplete/Unclear Wrong Stock Pulled Part Lost/Missing Part Moved Cuffs Maintenance Contamination Heat Treat Countersink Mislabeled Positioned Wrong Other Inspection Strip in Tube Cut Too Short Misread Power Loss/Surge Ripples in Bend Drill Holes Offset Out of Calibration Torque Waves in Extrusion Drawing Turning Sequence Finish Out of Sequence

Outside Dimensions

FAULT CATEGORY

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Wave/Twist in Tube

Folio

Work Ord <i>July 18, 2012 1</i>				*87	153*							Page 3
Item ID: Revision ID:	D350-588-0			Accept	*N900	1 040	100)*	Setup	Start	14.	S1*
Item Name:	Aft Door Ass	sembly								Stop	*N:	S2*
Start Date:	7/10/12	Start Qty: 1.00	*1*		Cust Item	ID:						
Required Date: Reference:	8/03/12	Req'd Qty: 1.00	*1*		Customer	:						
Approvals:	Process Pl	an:	Date:	Tooling:		Date:]	Run	Start Stop	*NI	R1*
	QC:		Date:	SPC (Y/N):)ate:				жор	*NI	R2*
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool#	Plan Code	Accept Qty	Rej Qty		Reject Number	Insp. Stamp
*150		QC5- Inspect part compl	eteness to step on W/O	0.00 AS	plulz							
QC		Memo		0.00	7							
Quality Control												
155		Pick Kit		0.00								
155				0.00								12/11/14
Packaging Packaging ,		Memo		0.00								
, and a			- (-									V
160		QC4- 100% Inspect kits	for completeness	0.00								
160					c.A.S							
QC		Memo		0.00	(AS 15 2.89			-				
Quality Control												
				le	27)14							

												DQA:	Date	e:
NCR:	Yes	/ No				WORK ORDER NON	-CO	NFORM	MANCE / UP	DATE				
												QA Closed:	Date	2:
Work Ord	er:					DISPOSITION				AGAINS	T DE	PARTMENT	/PROCESS	
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		Therm	Skid-tube Machining noforming Large Fab	Crosstub Small Fa Finishir Composit	b g		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	Cł	nief Eng	Desc	ription		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training														
*	1,.						FAUI	LT CATE	GORY	•				
Land	Landing Gear Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube Ripples in Bend					General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		Instruct Mainte Mislabe Misread	on Incomplete ions Incomplete/ nance led	'Unclear		Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss,	ct issing Wrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in	n Bend			Drill Holes		Offset						

Out of Calibration

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Order ID 87153 *87153* Page 4 July 18, 2012 11:21:45 AM Item ID: D350-588-041 Accept *N900040100* Setup Start **Revision ID:** Stop Item Name: Aft Door Assembly Start Qty: 1.00 **Start Date:** 7/10/12 **Cust Item ID:** Req'd Qty: 1.00 Required Date: 8/03/12 **Customer:** Reference: Run Process Plan: Tooling: Approvals: Date: Date: Stop QC: SPC (Y/N): Date: Date: Sequence ID/ Reject Reject Operation Set Up/ Tool ID Tool # Plan Accept Insp. Work Center ID Qty Description Code Qty Number Stamp **Run Hours** 170 Identify as per dwg & Stock Location: 0.00 *170* 0.00 Packaging Memo Packaging QC21- Final Inspection - Work Order Release 0.00 180 *180*

0.00

Memo

QC

Quality Control

MLJ 12-11-14 ML J 12-11-14

Picklist Print

July 18, 2012 11:21:44 AM

Work Order ID:

87153

Parent Item:

D350-588-041

Parent Item Name:

Aft Door Assembly

Start Date: 7/10/12

Required Date: 8/03/12

Page 1

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP P

04.02.04ReformatKJ/DS

KJ/DS IPP Rev:Q as per DSI9414 DD

Comments.	verified by:EC	IPP I			D 10.03.29 ve	erified by:EC							
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2445P		Purchased	No			110	Each	0.0000	1	1	-84	53	a
ANS26G832R9 Screw		Purchased	No			140	Each	382.0000	8	8/2	1/2	28/9	180
				Location		Loc Qty	<u>Lo</u>	c Code				,	20
				12	0181 1556	373 21 152							
,	JASUGI	03377		ST347	2151 8983	200							
W600D10	NASH49003631	Purchased	No			(140)	Each	0.0000	2	2	86	m	2297
Washer D2143 Hinge Bracket	211	Manufactured	No			140	Each	29.0000		1 (70·		
				Location		Loc Oty	Lo	oc Code		Ť	`		
	·				100	-28 10							
				ST004 82 ST198	335	19 19 38				IX	B81	08	<i>19.</i> ¹
DENED Hinge Bracket		Manufactured	No			(140)	Each	7.0000		1-1	384	010	386
				Location ST005	993	<u>Loc Otv</u> 7 7	<u>Lo</u>	c Code			To) -11	-13

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	-COI	NFORM	MANCE / UP	DATE		_	
						· · · · · · · · · · · · · · · · · · ·					QA Closed:	Date:	
Nork Ord	er:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part NCR	No.	•				Rework Scrap Use-as-is Work Order Update		ا Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	iption of work order update		nitial	Ac	tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date of	Verification	QC Inspector
oc/Data quip/Tooling perator laterial etup ther rocess upplier raining napproved													
							FAUL	T CATE	GORY				
Land	ng (ear				General					_		
		Bending Centre Not Concentric to O/S Cracks Crushed/Crimped. Cuffs Heat Treat Inspection Strip in Tube				Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short		1	on Incomplete ions Incomplete/ nance led	'Unclear	Ovalized Over/Under Part Incorre Part Lost/M Part Moved Positioned N Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
		Ripples in				Drill Holes		Offset		-			
		Torque W	aves in E	xtrusion		Drawing		Out of 0	Calibration				
•		Turning Se	eauence			Finish		Out of S	Seauence				

Outside Dimensions

Wave/Twist in Tube

Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July 18, 2012 11:21:44 AM

Work Order ID: 87153 **Start Date: 7/10/12** Required Date: 8/03/12 Parent Item: D350-588-041 Aft Door Assembly Start Qty: 1.00 Required Qty: 1.00 Parent Item Name: D2468 479.3174 No 7.25 Manufactured Seal Curcle 57,04 Loc Code Location Loc Qty an +1 5ns ST404 479.31737 72232 15.38 0.43737 79478 83542 463.5 D255 No Each 72,0000 Manufactured Mounting Channel Loc Qty Location Loc Code ST011 72 73297 2 82029 83369 85425 100.0000 D2586 Manufactured No Each Door Latch Loc Qty Loc Code Location ST203A 100 78833 83893 D2620 No Each 31.0000 Manufactured Latch Plate, 350 Spacepod Location Loc Qty Loc Code ST013 31 19 78991 86368 D2357=0 12-11-13 No Each 28.0000 Manufactured Hinge Bracket Location Loc Qty Loc Code ST019 28 75253 4 82261 24

NCR:	NCR: Yes / No WORK ORDER NON-CONFORMANCE / UPDATE													
Ň								•			QA Closed:	Da	ate:	
, Work Orde	er:				DISPOSITION				AGAINST	DEI	PARTMENT	PROCESS		
Part N			,		Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite			Water Je d. Eng. Coor e/Packaging Supplie		Engineering Quality Other
Root				Descri	ption of work order update		Initial	Act	ion		Sign &			
Cause Doc/Data	Dat	e Step	Qty	C	or Non-conformance	Ch	nief Eng	Descr	ription		Date	Verification	on	QC Inspector
Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved						FAUI	LT CATE	GORY						
Landi	ng Gear				General		_				_			
	Cracks	Not Conce		/s	Bend BOM/Route Broken/Damaged		-i	on Incomplete			Ovalized Over/Under Part Incorre	ct		Pressure/Forced Temperature/Cure Weld
	Crush	ed/Crimped	1.	-	Burrs	-	Mainte	ions Incomplete/l	unciear	<u> </u>	Part Lost/Mi Part Moved	Szing	<u> </u>	Wrong Stock Pulled
1	⊢	reat 🥳		\vdash	Contamination Countersink	\vdash	Mislabe			<u> </u>	Part Moved Positioned V	Vrong		
'	—	reat 💢 tion Strip in	a Tuba	-	Cut Too Short	-	Misread			\vdash	Positioned v	_	Г	Other
	⊢	s in Bend	riube		Drill Holes	\vdash	Offset	ı		L	Jrowei 1055/	Juige	<u></u>	Other
	$oldsymbol{arphi}$	s in Bend • Waves in	Extrucion	—	Drawing	-	╡	^alibration						

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

July 18, 2012 11:21:44 AM

Work Order ID:	87153								
Parent Item:	D350-588-041							Date: 7/10/12	Required Date: 8/03/12
Parent Item Name:	Aft Door Assembly						Star	t Qty: 1.00	Required Qty: 1.00
22857-2 Hinge Bracket		Manufactured	No		140	Each	16.0000		189154489
				<u>Location</u>	Loc Qty		Loc Code		· ·
				ST019	16				
				78904	16				
MS21042L08		Purchased	No		(140)	Each	833.0000	8	8
Vut								· · · · · · · · · · · · · · · · · · ·	
				Location	Loc Qty		Loc Code		·
				ST300	33				
				121524	33				<u> </u>
				ST317	800				
				122141	800				K
MS21042L3		Purchased	No		140	Each	3,107.0000	2	2 $\approx (23)(x^{2})$
Nut									1111000s J
				Location	Loc Qty		Loc Code		
				ST300	1107				
				117885	32				<u></u>
				119017	757				<u> </u>
				119075 121444	138 180				
				ST317	2000				
	200°			122141	2000				
MS27039-1-15		n	No	122141	140	Each	31.0000	2	2 122-
Screw		Purchased	140		140	Lucii	31.0000	-	m/20552
ociew		:		T4:	Las Otro		Loo Codo		COO(11)
				Location	Loc Qty		Loc Code		8912-11-13-
				ST291	31				<u> </u>
				118574 119736	2				
				121243	1 28				

										DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	100	NFORI	MANCE / UP	PDATE	QA Closed:	Date:	
Work Order:					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part No. NCR No.					Rework Scrap Use-as-is Work Order Update		i	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	1	Initial	Ad	ction	Sign &	-	
Cause	Date	Step	Qty		or Non-conformance	Ch	ief Eng	Desc	cription	Date	Verification	QC Inspector
Doc/Data												
Equip/Tooling								ļ				
Operator												
Material]											
Setup												
Other]											
Process												

Landi	ıg (Gear		General	_			
		Bending		Bend	Grain	Ovalized		Pressure/Forced
		Centre Not Concentric to O/S		BOM/Route	Hardware	Over/Under tolerance		Temperature/Cure
		Cracks		Broken/Damaged	Inspection Incomplete	Part Incorrect		Weld
		Crushed/Crimped.		Burrs	Instructions Incomplete/Unclear	Part Lost/Missing		Wrong Stock Pulled
		Cuffs Contamination			Maintenance	Part Moved		
		Heat Treat		Countersink	Mislabeled	Positioned Wrong		_
		Inspection Strip in Tube		Cut Too Short	Misread	Power Loss/Surge	Ŀ	Other
		Ripples in Bend		Drill Holes	Offset			
		Torque Waves in Extrusion		Drawing	Out of Calibration			
		Turning Sequence		Finish	Out of Sequence			
	Wave/Twist in Tube Folio				Outside Dimensions			

FAULT CATEGORY

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Supplier Training Unapproved

Picklist Print

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Page 4

Work Order ID:	87153									
arent Item:	D350-588-041				,)		Star	t Date: 7/10/12	Required Date: 8/03	3/12
Parent Item Name:	Aft Door Assembly						Sta	rt Qty: 1.00	Required Qty: 1.00)
VAS1149DN832J VASHER		Purchased	No		140	Each	409.0000	8	m 12244	SP
				Location	Loc Qty		Loc Code			J ,
				ST298	409					
				119717	41					
				120422	368					
N526C1032R9		Purchased	No		155	Each	70.0000	2.	2 gb	
SM)				<u>Location</u>	Loc Qty		Loc Code		0	-
2/11/2				ST348	70					
				116304	10					
				119449	60			1194	<u>149</u>	
N526 <u>G832R8</u> crew		Purchased	No		155	Each	127.0000	122	814 JB	## ## ## ## ## ## ## ## ## ## ## ## ##
SWO				Location	Loc Qty		Loc Code		V	Garage
				ST346	115					
				120717	15					
				122151	100			- <u></u>		
				ST347	12					
				116410	3					
				116471	5					
				118926	4					
N960JD10 ShO	NAS1149D0363J	Purchased	No		155	Each	0.0000	2 232	148 20	
2(50) SA Cacker Doubler, Hinge		Manufactured	No		155	Each	36.0000	2 8686	$33^2 - 18$	12/11
ickei Doublei, Hillge				Location	Loc Qty		Loc Code			
				ST005	36					
				82136	16					
				85513	20					

												DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-C	O	NFORM	MANCE / UP	DATE					
									·			QA Closed:	Dat	te:	
Work Ord	er:					DISPOSITION				AGAI	NST DE	PARTMENT	PROCESS		
Part NCR	No.					Rework Scrap Use-as-is Work Order Update		t Therm	Skid-tube Machining noforming Large Fab	Crosst Small Finisl Compo	Fab ning		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	otion of work order update		nitial	Ad	ction		Sign &			
Cause		Date	Step	Qty	C	or Non-conformance	Ch	ief Eng	Desc	cription	•	Date	Verification	n	QC Inspector
Doc/Data									,						, , , , , , , , , , , , , , , , , , , ,
Equip/Tooling							1								
Operator															
Material															
Setup															
Other							1								
Process															
Supplier								:							
Training															
Unapproved							ŀ								
						F	AUL	T CATE	GORY						
Landi	ng (Gear				General						_			-
		Bending				Bend		Grain				Ovalized			Pressure/Forced
		Centre No	ot Concer	ntric to (o/s	BOM/Route		Hardwa	re			Over/Under	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete			Part Incorre	ct		Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear		Part Lost/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance			Part Moved			_
	Γ	Heat Trea	ıt			Countersink		Mislabe	led			Positioned V	Vrong		
	Γ	Inspection	n Strip in	Tube		Cut Too Short		Misread	I			Power Loss/	Surge		Other

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish Folio

Picklist Print

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Page 5

Work Order ID:	87153										
Parent Item:	D350-588-041						Star	rt Date: 7/10/12		Required Date: 8/03/1	12
Parent Item Name:	Aft Door Assembly						Sta	rt Qty: 1.00		Required Qty: 1.00	4.04
22151 acker Doubler, Hinge		Manufactured	No		155	Each	40.0000	20	2 .	~ J & .	
				Location	Loc Qty		Loc Code			•	
SW				ST005	40						
J" J				82137	20						
				85514	20			85	214		
2153 oor Prop		Manufactured	No		155	Each	52.0000		1	28	
540				Location	Loc Qty		Loc Code			O	
				ST272	52						
				78369	16						
				85865	36			_ 85	862		
2154 tud Bracket		Manufactured	No		155	Each	60.0000		1	20	S
5W				Location	Loc Qty		Loc Code	- 1			4
31X2				ST005	60						
				64312	1						
				77024	3						
				82333	56			. 823	33		
2237 triker Plate		Manufactured	No		155	Each	62.0000	2 89	925	- JB 1	2/11/14
SKO				Location	Loc Oty		Loc Code			v	<u>2/11/14</u>
				ST006	42						
				64426	2						
				66139	1						
				82062	3						
				83376	36						
				ST009	20						
				85476	20						

												DQA:	Date	: :	
NCR:	Yes	/ No				WORK ORDER NON-	COI	NFORM	JANCE / UP	DATE		·		-	
									-			QA Closed:	Date	9:	
Work Ord	or.					DISPOSITION				AGAINST E	ЭΕ	PARTMENT	PROCESS		
Work Ord	٠					Rework	7		Skid-tube	Crosstube]	Water Jet	٦	Engineering
Part I	Nο.					Scrap	1	1	Machining	Small Fab		Pro	d. Eng. Coor.	\dashv	Quality
						Use-as-is	1		noforming	Finishing		!	re/Packaging	ᅦ	Other
NCR I	No.					Work Order Update	1		Large Fab	Composite		,	Supplier		
	•								- <u> </u>						·
Root					Descri	ption of work order update		Initial	Ac	tion		Sign &			•
Cause		Date	Step	Qty		or Non-conformance	Ch	nief Eng	Desc	ription		Date	Verification		QC Inspector
Doc/Data															
Equip/Tooling	Ш														
Operator															
Material	Ш														
Setup	Ц														
Other	Ш														
Process															
Supplier	Ш		i.										<u>.</u>		
Training	Ш														
Unapproved	Ш		<u> </u>				<u> </u>								
							AUI	LT CATE	GORY						
Landi	_				_	General	_	la .		Г		۱	Г		lo (5)
	Н	Bending				Bend	\vdash	Grain		}		Ovalized	<u>+-1</u>		Pressure/Forced
	H	Centre No	ot Concei	ntric to C	^{1/S} -	BOM/Route	-	Hardwa				Over/Under	<u> </u>		Temperature/Cure Weld
	Н	Cracks	C.:			Broken/Damaged	\vdash	4 `	on Incomplete	// / · · · · · · · · · · · · · · · · ·		Part Incorre	-		
	Н	Crushed/	crimped.		\vdash	Burrs	-	Mainte	ions Incomplete,	Unclear		Part Moved	issing [_	Wrong Stock Pulled
	H	Cuffs			-	Countarink	-	Mislabe		}		Part Moved Positioned \	Mrong		
	H	Heat Trea		Tubo	-	Countersink Cut Too Short	-	Misread		}		Positioned (Other
	\vdash	Inspectio	-	rube	-	Drill Holes	\vdash	Offset	ı	Ł		Trower ross/	Zuige [Other
l	1 1	Ripples in	Della		I .	באוטוו וווטופא	I	Jourset				*			

Out of Calibration

Out of Sequence

Outside Dimensions

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

July 18, 2012 11:21:44 AM

Work Order ID:	87153										
Parent Item:	D350-588-041						Star	t Date: 7/10/12		Required Date: 8/9	03/12
Parent Item Name:	Aft Door Assembly						Sta	rt Qty: 1.00		Required Qty: 1.0	00
02461		Manufactured	No		155	f	684.4367	7.25	7.25	_	
leoprene "D" Seal		Within and the Ca								78	
				Location	Loc Qty		Loc Code			,	
Cut alty 4 /	-> measure Sizluly			ST402	184.436684						
P 67 . 11	-> we so co			39782	6.5						
C 07.000	Sismit			55054	4			<u> </u>			
				63880	14.8237						
Sim	\mathcal{O}			73644	159.112984			736	111		
				ST402A	500			156	77		1
				85225	500						
2589 SWS		Manufactured	No		155	Each	0.0000	7	18	8194 2	
eys, Key Chain, 350 H	inge							42			
2690417		Manufactured	No		155	Each	31.0000	(IEE)	1	- 4	,
able											~~~ ~
Sim				Location	Loc Qty		Loc Code				
				ST016	31						
				64786	1						
				66510	1						
				84069 85866	19			858	60		
				856649	6			0 - 1			
2858-0		Manufactured	No	00017	155	Each	37.0000				_
inge Bracket		Manufactured	110		100	Lucii	37.0000			78	1.24) 13 138
				Location	Loc Qty		Loc Code				
Smy							Luc Coue				
ŕ				ST019 63695	37						
				77019	1 12			-			
				82337	24			823	31		

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER NON-	CO	NFOR	MANCE / UPI	DATE		···	
											QA Closed:	Date:	;
Work Ord	er.					DISPOSITION				AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Rework Scrap Use-as-is Work Order Update] 1	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	-1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root		[<u> </u>		Descri	I iption of work order update	\top	Initial	Act	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	- 1	nief Eng		ription	Date	Verification	QC Inspector
Doc/Data			<u> </u>				\dagger				<u> </u>		
Equip/Tooling													
Operator													
Material													
Setup		1											
Other													
Process		1											
Supplier												! !	
Training													
Unapproved		1					İ						
							FAU	LT CATE	GORY				
Landi	ng (Gear				General	_	_			_	_	_
	L	Bending				Bend	L	Grain		<u></u>	Ovalized		Pressure/Forced
		Centre N	ot Concer	ntric to	o/s	BOM/Route		Hardwa	ire		Over/Under	tolerance	Temperature/Cure
		Cracks				Broken/Damaged	L	Inspect	ion Incomplete		Part Incorre	ct	Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/l	Unclear	Part Lost/M	issing	Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Moved		
1		Heat Tres	at .			Countersink		Mislahe	hale		Positioned \	Mrong	

Misread

Out of Calibration
Out of Sequence

Outside Dimensions

Offset

Power Loss/Surge

Other

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Inspection Strip in Tube

Torque Waves in Extrusion

Cut Too Short

Drill Holes

Drawing

Finish

Folio

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July 18, 2012 11:21:44 AM

Vork Order ID:	87153						C44 F	N-A 7/10/10	Danis J Data 8/02/	/12
Parent Item:	D350-588-041							Date: 7/10/12	Required Date: 8/03/	
arent Item Name:	Aft Door Assembly						Start	Qty: 1.00	Required Qty: 1.00	
2858-2		Manufactured	No		155	Each	32.0000			
linge Bracket								- WE		
				Location	Loc Qty		Loc Code		•	
Sm				ST019	32					
-10				64787	1					
				77020	8					
				82336	23			\$2336		
6-57-815045504ROL		Purchased	No		155	sf	2,764.4910	0	V .	Q.
81 9oz Glass 50"x125	yd							12323	iJb	
				Location	Loc Oty		Loc Code		V	
				CA	2764.491					
2/a-	7			104845	3					
				108932	18					
				111166	392					
				113905	564					
				117602	664.651					
				119099	1122.84					
\$20426AD3-4 VET		Purchased	No		155	Each	2,552.0000	123021	2 JB	
				Location	Loc Oty		Loc Code		U	
2 K				ST316	2552					
				104374	236					
				110398	2316					
S20470A'D445		Purchased	No		155	Each	1,136.0000	18 1	8 /	10
vet, Universal Head								12245	<u> 48</u>	12/11
≤ 1.4				Location	Loc Qty		Loc Code		V	S
Sho				ST319	1136					
				118405	389					•
				120142	747					

											DO	QA:	Date	e: _	
NCR:	Yes	/ No				WORK ORDER NON-O	100	NFORM	MANCE / UP	DATE			_		
											QA Clos	ed:	Date	e:	
Work Ord	er:					DISPOSITION				AGAINST DE	PARTME	NT/	PROCESS		
Part I	No.					Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	1		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update	1	Initial	Ac	ction	Sign 8	<u> </u>		\Box	
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	cription	Date	•	Verification	<u> </u>	QC Inspector
Doc/Data		·					ļ								
Equip/Tooling															
Operator							1								
Material							1								
Setup															
Other					ļ						:				
Process															
Supplier		•	ļ										:		
Training															
Unapproved															
-						F	AUL	T CATE	GORY						
Landi	ng (3ear				General		_			_		_		
		Bending				Bend		Grain			Ovalized	t	1_		Pressure/Forced
		Centre No	ot Concer	ntric to	o/s	BOM/Route		Hardwa	re		Over/Ur	nder	tolerance		Temperature/Cure
		Cracks				Broken/Damaged		Inspecti	on Incomplete		Part Inc	orre	ct [Weld
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete,	/Unclear	Part Los	t/Mi	ssing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	enance		Part Mo	ved	_		
		Heat Trea	nt			Countersink		Mislabe	eled		Position	ed V	Vrong		
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	d		Power L	.oss/	Surge	\Box	Other

Offset

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

Drill Holes

Drawing

Finish

Folio

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July 18, 2012 11:21:44 AM

ork Order ID: rent Item: rent Item Name:	87153 D350-588-041 Aft Door Assembly								Date: 7/10/12 : Qty: 1.00	_	uired Date: 8/03/1	_
S210421.08j		Purchased	No			155	Each	833.0000	00	10	6	Á
				Location		Loc Oty		Loc Code				
Smo				ST300		33						
•				12	1524	33						
	to the second			ST317		800						
					2141	800			_ 122/	41		
210421.3		Purchased	No			155	Each	3,107.0000	4	4 /2	3260	
				Location		Loc Qty		Loc Code				رس ا
5H)				ST300		1107						
374				11	7885	32						
				11	9017	757			-			
					9075	138						
					1444	180						
				ST317		2000						
				12	2141	2000			<i></i>		1	
27039408-01 ew		Purchased	No			155	Each	59.0000	27	2 ~		8
5W>				Location		Loc Qty		Loc Code				
2K /				ST290		7						
				11	7441	7						
				ST292		52						
					6289	2						
				12	0833	50			1208	35		
S1149DN832J ASHER		Purchased	No			155	Each	409.0000	1225	141	15 1	2/11/13
< ^				Location		Loc Qty		Loc Code		•		
5mB				ST298		409		-				
					9717	41						, V
					0422	368						

									DQA:	Date:	
NCR: Yes	/ No				WORK ORDER NON-C	ONFO	RMANCE / U	PDATE	QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.					Rework Scrap Use-as-is Work Order Update	The	Skid-tube Machining rmoforming Large Fab	Crosstube Small Fab Finishing Composite	1	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descrip	tion of work order update	Initial	,	Action	Sign &		
Cause	Date	Step	Qty	01	r Non-conformance	Chief Er	g De	scription	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved											

			FAULT CATEGORY		
Landin	ng Gear	General			
	Bending	Bend	Grain	Ovalized	Pressure/Forced
	Centre Not Concentric to O/S	BOM/Route	Hardware	Over/Under tolerance	Temperature/Cure
	Cracks	Broken/Damaged	Inspection Incomplete	Part Incorrect	Weld
	Crushed/Crimped.	Burrs	Instructions Incomplete/Uncl	ear Part Lost/Missing	Wrong Stock Pulled
	Cuffs	Contamination	Maintenance	Part Moved	
	Heat Treat	Countersink	Mislabeled	Positioned Wrong	
Γ	Inspection Strip in Tube	Cut Too Short	Misread	Power Loss/Surge	Other
	Ripples in Bend	Drill Holes	Offset	,	
	Torque Waves in Extrusion	Drawing	Out of Calibration		
	Turning Sequence	Finish	Out of Sequence		
ĺ	Wave/Twist in Tube	Folio	Outside Dimensions		

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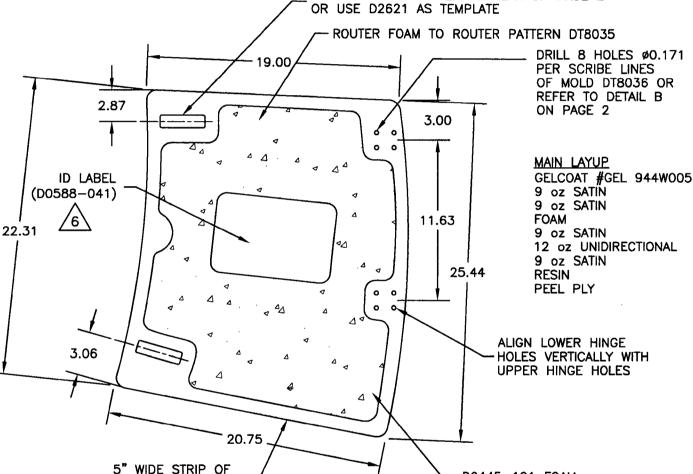
DESIG	ΪΒ _Ι	CB	DART AEROSPACE LŢD HAWKESBURY, ONTARIO, CANADA	
CHEC	KED	APPROVED_///	DRAWING NO.	REV. D
	一串	#	D2445 SHEET	1 OF 2
DATE			TITLE	SCALE
06.0	06.09		AFT BAGGAGE DOOR	1:7
Α		97.07.15	NEW ISSUE	
В		02.01.24	ADD D2621; D2445-101	
С		04.02.09	REMOVE D2621; UPDATE NOTES	

ADD DIMENSIONS TO PERIMETER

RELEASED de 11.13 =

CUT 2 PLACES AS PER DETAIL A ON PAGE 2

06.06.09



D

NOTES:

1) USE MOLD DT8036 FOR DOOR LAYUP. TRIM AND DRILL PER DT8619

ALL AROUND

2) RESIN: DERAKANE 411/510A40/470-36

12 oz UNIDIRECTIONAL FIBERGLASS

- 3) FOAM: 3/8" A500 CORE CELL OR DIVINYCELL OR AIREX OR KLEGECELL R-75
- 4) FIBRE: 9.7 oz 7781 WEAVE "S" GLASS ("9 oz SATIN")
 - 12 oz UNIDIRECTIONAL FIBERGLASS ("12 oz UNIDIRECTIONAL")
- 5) BOND FOAM CORE TO LAMINATE USING POLYBOND B46F
- 6) LAMINATE LABEL USING SURFACE VEIL AND EPOXY RESIN.
- LAMINATE PER DART QSI 006 4.0
- 8) LAMINATION SCHEDULE PER THIS DRAWING
- 9) FINISH INSIDE WITH DUPONT HIGHBUILD GREY PRIMER 1144-S
- 10) ALL DIMENSIONS ARE IN INCHES
- TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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D2445-101 FOAM

81153 D12-57-12

											DQA:	Dat	te:	
NCR:	Yes	/ No				WORK ORDER NON-O	COI	NFORM	MANCE / UPDATE				•	
											QA Closed:	Dat	te:	
Work Ord	er:					DISPOSITION AGAINST D			AINST DE	PARTMENT	/PROCESS			
Part No				Part No.			Rework Skid-tube Crosstube Scrap Machining Small Fab Use-as-is Thermoforming Finishing er Update Large Fab Composite			all Fab		Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
Root					Descri	ption of work order update		Initial	Action		Sign &			
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Description		Date	Verification	n	QC Inspector
Doc/Data											,			
Equip/Tooling													ļ	
Operator														
Material														
Setup														
Other							1							
Process														
Supplier														
Training							İ							
Unapproved														
FAULT CATEGORY														
Landing Gear General										_				
Bending			Bend		Grain			Ovalized			Pressure/Forced			
Centre Not Concentric to O/S			BOM/Route		Hardwa	re		Over/Under	tolerance		Temperature/Cure			
Cracks			Broken/Damaged		Inspecti	on Incomplete		Part Incorre	ct		Weld			
		Crushed/	Crimped.			Burrs		Instruct	ions Incomplete/Unclear		Part Lost/Mi	issing		Wrong Stock Pulled
		Cuffs				Contamination		Mainte	nance		Part Moved			-
		Heat Trea	t			Countersink		Mislabe	led		Positioned V	Vrong		
Inspection Strip in Tube			Cut Too Short		Misread			Power Loss/	Surge		Other			

Offset

Out of Calibration
Out of Sequence

Outside Dimensions

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Turning Sequence

Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

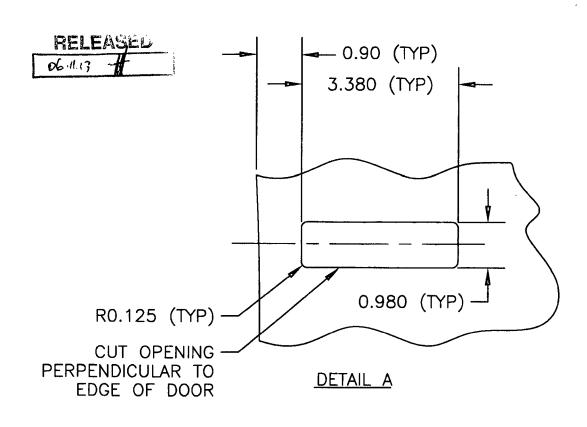
Drill Holes

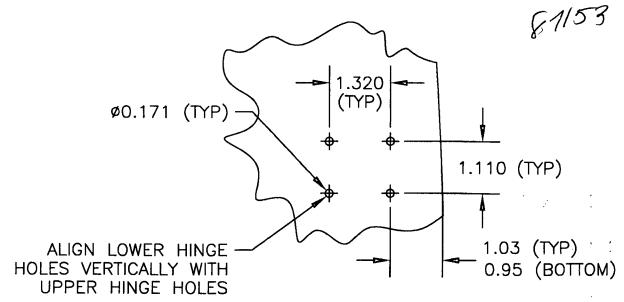
Drawing

Finish Folio



JB /	CB	DART AEROSP HAWKESBURY, ONTARI	
CHECKED 2	APPROVED //	DRAWING NO.	REV. D
1 4	1	D2445	SHEET 2 OF 2
DATE		TITLE	SCALE
06.06.09		AFT BAGGAGE DOOR	1:2





DETAIL B

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NCR:	Yes	/	No
		,	

NCR: Y	·										
					1				QA Closed:	Date	:
Work Orde	r:				DISPOSITION	ļ		AGAINST DE	PARTMENT	/PROCESS	
					Rework]	Skid-tube	Crosstube]	Water Jet	Engineering
Part N	0.				Scrap	1	Machining	Small Fab] Pro	d. Eng. Coor.	Quality
					Use-as-is	Th	ermoforming	Finishing	Rec/Sto	re/Packaging	Other
NCR N	0				Work Order Update]	Large Fab	Composite]	Supplier]
Root				Descri	tion of work order update	Initia	I A	ction	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chief E	ng Des	scription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling						l					
Operator					•						
Material											
Setup											
Other											
Process											
Supplier											
raining		ŀ									
Jnapproved											
•					F	AULT CA	TEGORY				
Landin	g Gear			_	General			_	٦	_	_
	Bending				Bend	Gra	in	L	Ovalized	_	Pressure/Forced
<u> </u>	Centre No	ot Concei	ntric to (o/s	BOM/Route	Har	dware		Over/Under	tolerance	Temperature/Cure
Ĺ	Cracks		Broken/Damaged		Inspection Incomplete		Part Incorre	<u> </u>	Weld		
1	Crushed/Crimped.		Burrs	—	ructions Incomplete	≥/Unclear	Part Lost/M	_	Wrong Stock Pulled		
Cuffs		Contamination	Ма	intenance		Part Moved					
	Heat Treat		Countersink	Mis	abeled		Positioned \	_	,		
	Inspection	n Strip in	Tube	<u> </u>	Cut Too Short	Mis	read	L	Power Loss,	'Surge	Other
	Ripples in	Bend			Drill Holes	Offs	et				
	Torque W	/aves in E	xtrusio	ո 🗀	Drawing	Out	of Calibration				
٠, [Turning S	equence			Finish	Out	of Sequence				
	Wave/Twist in Tube				Folio	Out	side Dimensions				

DQA: Date:

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DELASTEK Inc. 2699 5e Avenue Local 14, C.P. 10100 Grand-Mère, Québec G9T 5K7 Canada

Tel.: (819) 533-5788 Fax: (819) 533-3494

PACKING SLIP

CERTIFICATE OF COMPLIANCE

Ship To

Invoice No.	44870.
Customer No.	DART US

Bill To	Ship To	

DART AEROSPACE LTD 1270, Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada

Telephone: 613-632-5200 Contact: Linda Lacelle

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on

☐ Quality

(4) Ship.

file at our plant and available for review upon request

Adm.

Cust.

DART AEROSPACE LTD 1270, Aberdeen Street Hawksbury, Ontario K6A 1K7 Canada

Telephone: 613-632-5200 Contact: Linda Lacelle

Accepted by

Quality department

AQ-357

Ship Date	Order Date	Date Our SC	0#	Ordered by		Your PO#	Terms		
07-09-2012			ie PO17478 Net 30 days USA						
Ship Via			F.O.B.	**		Salesperson	GST/PST		
FEDEX	P1 Collect		Point de départ		Claı	ide Lessard, ext. 233			
Order Qty	B.O. C Qty	Current Ship.	Item number			Descript	ion		
1	ing in		OKC134-0013 Serial # B87153. WB #7989-1735-8620	7/09/	B87153 Drawing N	l° : D2445 Rév D N 43	7 SEP. 2017 39 35 - 86 20 L		



DELASTEK AERONAUTIQUE Mardi, 2012-07-24 09:04:48 Date: Utilisateur: marc dubé Feuille de Procédé Client : DART US DART AEROSPACE Nom Dessin : N° D2445, AFT BAGGAGE DOOR Numéro Job : 43209 Numéro Article : DKC134-0013 Numéro : 3959 Numéro Dessin : D2445 Numéro B.A. Projet Numéro : DK-362 Cette fois : 2012-07-24 Révision dessin : D Prsht Rev. : NC Matériel : Composite Prem. fois Type Date Dûe : 2012-09-05 Qté: 1 Ud UNITE : 39934 Job précédente Ècrit par Vérifié & Approuvé par B 87153 Commentaires : N° de pièce Client: D2445 Process Sheet Rev.: 02 AAC1885 était AC0883, AAC1887 était AC0884, , # de projet était DK-134. Produit additionnel Numéro Job: Machine ou # Séq.: Description: 1.0 AAC1616 N° 83634, Frekote Loctile Wolo Qty.: 0.200 UNITE(s)/Unit Total 0.200 UNITE(s) N° 83634, Frekote Loctite Wolo 2.0 PREP-GENERAL Preparation du matériel Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Comment Faire la préparation du moule N° DT-8024 selon IG 0009. 3.0 AMB0350 Gel Coat Blanc N° Gel 944W005 Comment Qty.: 0.200 KILOGRAMME(s)/iJnit Gel Coat Blanc N° Gel 944W005 4.0 AMB0286 Comment Qty.: 0.0320 GALLON(s)/Unit Total Catalyst N° DDM-9 N° de Lot 5.0 PREP-GENERAL Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation de la résine selon les quantitées requises, mix ratio 1.5% catalyst par quantité de résine

Date:

Mardi, 2012-07-24 09:04:48

Utilisateur:

marc dubé

Feuille de Procédé

Nom Dessin:

Numéro

Client:

Numéro Job:

Numéro Job:

DART US DART AEROSPACE

43209

Séq.:

Machine ou Opération:

Description:

DKC134-0013

6,0

GEL COAT

Application du Gel Coat



Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

N° D2445, AFT BAGGAGE DOOR

7.0

AAC1885

Tissu à délaminer Release ply B

Comment

Qty.:

1.52 VERGE(s)/Unit Total:

Tissu à délaminer Release ply B

Faire l'application du Gelcoat selon 1G 0019

1.52 VERGE(s)

de Lot:

8,0 Comment

Comment

AAC1887 Qty.:

Wrightlon 5200 Bleu P3

3.33 VERGE(s)/Unit Total: 3.33 VERGE(s)

Wrightlon 5200 Bleu P3

Feutre de drainage

9.0 AC0885

2.78 VERGE(s)/Unit 2.78 VERGE(s) Total:

Qty.:

AC0943 10,0 Comment

Stretchion 200 poche à vide Vert 2.00 PIED(s)

11.0

Qty.: AMB0214

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Comment

2.0 VERGE(s)/Unit Total: Qty.:

2.0 VERGE(s)

9.7 oz Weave "S" glass #FG-778150-125Y Volan Finish

Ruban à gommer jaune #: T/AT-200Y

12.0

AMB0349

Fiberglass 12 oz Unidirectiona

Qty.: 0.33 VERGE(s)/Unit

2.00 PIED(s)/Unit

0.33 VERGE(s)

Fiberglass 12 oz Unidirectional.

ir de Lot: 1. 22549-/

13.0

AC0886

1.2500 ROULEAU(s)

Comment

Qty.: 1.2500 ROULEAU(s)/Unit

14.0

Préparation du matériel

Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Tailler le matériel, selon les différents paterns de découpe comme suit:

4 plis de tissus de 9.7 oz.

1 pli de 12 oz. pour tout le contour de la pièce par 5" de large.

3 fois le sac à vide Strechlon 200.

- 3 fois le film perforé P-3
- 3 fois le feutre de drainage
- 2 fois le tissu à délaminer (non nécessaire lors du bagging du core).

Appliquer le ruban jaune tout le tour du strechlon 200 en laissant le papier sur le coté non en contact avec le sac à vide.

Date: Mardi, 2012-07-24 09:04:48 Utilisateur: marc dubé Feuille de Procédé DART US DART AEROSPACE Client: Nom Dessin: N° D2445, AFT BAGGAGE DOOR 43209 Numéro Job: Numéro DKC134-0013 Numéro Job: # Séq.: Machine ou Opération: Description: Afin d'accélérer le processus de taillage, tailler les plis de 9.7 oz. tous en même temps, en les superposant les uns sur les autres. **d**ceau; 15.0 Catalyst N° DDM-9 Comment Qty.: 0.0130 GALLON(s)/Unit Total, Catalyst N° DDM-9 N° de Lot: 16.0 AMB0212 Résine (411B7530) 411-350 promo 75min. Comment Qty.: 0.360 KILOGRAMME(s)/Unit Total: 0.360 KILOGRAMME(s Résine (411B7530) 411-350 promo. 75min. N° de Lot: 17.0 Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation de la résine selon les quantité requises, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350. 18.0 Faire le laminage Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs À l'aide d'un rouleau 2" dia. appliquer une couche de résine N° 411-350 sur le moute N° DT 8036 et ensuite imbiber un plis de tissu 9.7 oz. Recommencer l'opéaration pour le deuxième pli. 19.0 Faire le bagging sur la piece Comment 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la poche à vide selon 1G 0012.

Laisser sécher pendant 4 heures minimum.

portain a state of similaria

Heure Curing début:

_ Heure Curing Fin:_

Y:00

DateX3/DX/Steau

Date: Mardi, 2012-07-24 09:04:48 Utilisateur: marc dubé Feuille de Procédé Client: DART US DART AEROSPACE Nom Dessin: N° D2445, AFT BAGGAGE DOOR 43209 Numéro Job: Numéro DKC134-0013 Numéro Job: # Séq.: Machine ou Opération: Description: 20.0 AMB0286 Catalyst N° DDM-9 Comment 0.0042 GALLON(s)/Unit Total: Qty.: 0.0042 GALLON(s) N° de Lot: 1-27129-Catalyst N° DDM-9 AMB0212 Résine (411B7530) 411-350 promo. 75min. 21.0 Comment Qty.: 0.120 KILOGRAMME(s)/Unit Total. 0.120 KILOGRAMME(s) Résine (411B7530) 411-350 promo. 75min. N° de Lot: 1 22.0 PREP-GENERAL Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Faire la préparation de la résine selon les quantités requise, mix ratio 1.5% de catalyst N° DDM-9 par quantité de résine N° 411-350, Imbiber toutes les surfaces du Foam Core selon IG0105. Date: 17-11-15 Sceau: 23.0 AAC1611 Polybond B46F Comment Qty.: 0.045 KIT(s)/Unit Total: Polybond B46F N° de Lot: DKC134-0029 24.0 Comment Qty.: 1 UNITE(s)/Unit Total: 1 UNITE(s) Foam Core N° D2445-101 (Pour AFT Baggage Door) 25.0 Assemblage mécanique Comment Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs Assembler in DKC134-0029 selon IC 0033 26.0 Faire le bagging sur la pièce Comment Setup: 0.00Hrs/ Run: 0.0000Min | Total Run : 0.0000Hrs Faire la poche à vide selon IG 0012 Retirer le bagging avant la fin de la polymérisation (entre 1h et 1h30) afin d'enlever le surplus de Polybond. Heure Fin Curing:

Date:

Mardl, 2012-07-24 09:04:48

Utilisateur:

marc dubé

Feuille de Procédé

Client:

43209

DART US DART AEROSPACE

N° D2445, AFT BAGGAGE DOOR

Numéro DKC134-0013

Numéro Job: Numéro Job:



Séq.:

Machine ou Opération:

Description:

27.0

AMB0286

Catalyst N° DDM-9

Comment

Qty.:

Catalyst N° DDM-9

0.1360 GALLON(s)/Unit Total: N° de Lot.

28.0

AMB0212

Résine (411B7530) 411-350 promo, 75min.

Comment

Qty.: 0.360 KILOGRAMME(s)/Unit Total:

0.360 KILOGRAMME(s)

Résine (411B7530) 411-350 promo. 75min.

N° de Lot:

29.0

PREP-GENERAL

Préparation du matériel





Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Faire la préparation de la résine selon les quantités requises, mix ratio 1.5% de catalyst

N° DDM-9 par quantité de résine N° 451-350.



30.0

Faire le laminage





Comment

0.00Hrs/ Run: 0.0000Min Total dan: 0.0000Hrs

Faire le laminage d'un pli de 9.7 oz.

Faire le laminage du plis de tissu 12 oz. tout le tour de la porte en prenant bien soin que les deux bandes allant dans le coin droit en bas se superposent

Faire le laminage du dernier pli de 9.7 oz.



310

Faire le bagging sur la pièce



Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs



Faire la poche à vide selon IG 0012

Laisser sécher pendant 4 heures minimum.

Heure Curing Fin: 800





Mardi, 2012-07-24 09:04:48

Utilisateur:

marc dubé

Feuille de Procédé

Client: Numéro Job:

43209

DART US DART AEROSPACE

Nom Dessin: N° D2445, AFT BAGGAGE DOOR

Numéro

DKC134-0013

Numéro Job:



Séq.:

Machine ou Opération:

Description :

32.0

DÊMOULAGE

Démoulage de la pièce





Comment

Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

Démouler la pièce en faisant bien attention aux coins & Edges.

33.0

Trimage



Setup: 0.00Hrs/ Run: 0.0000Min Total Run: 0.0000Hrs

À l'aide du gabarit N°DT 8619 trimer la pièce en utilisant un router muni d'un couteau 1/4" et d'un " Bushing " 1/16" de mur.

Percer les " Latch " et les trous de pent de sein N° D2445.

34.0

Label N° D0588-041

Comment Qty.:

1 UNITE(s)/Unit Total:

Label N° D0588-041

N° de Lot:

35.0 AAC1609

Surface Veil

Comment Qty.:

0.07 VERGE(s)/Unit 0.07 VERGE(s) Total:

Surface Veil

N° de Lot:

AAC1220 36.0 Comment

Résine Mia-Poxy 100

Qty.:

AAC1221

0.007 GALLON(s)/Unit Total: 0.007 GALLON(s) N° de Lot:

Résine Mia-Poxy 100

37.0

Qty.: 0.007 QUART(s)/Unit Total: Durcisseur 95 Pour Résine Mia-Poxy

0.007 QUART(s)

38.0 ASSEMBLAGE





Comment

Coller le label N° D0588-041 selon IG 0111.



	DART US 43209	DART AEROSPACE		Nom Dessin: Numéro		N° D2445, AFT BAGGAGE DOOR DKC134-0013
Numéro Job:			****	Marie Constitution of the		
# Sĕq.:	Machine o	u Opération:		De	escri	iption :
39.0	AAC1492			N° P-15-3, Adtech Micro Ultra	ra Fill	ler
Comment	,	0.014 GALLON(s)/Unit -3, Adtech Micro Ultra F		0.014 GALLON(s) #de Lot: 7 SC	57	97-1
40.0	FINITION	MENT FEN MEN		Finition Générale	e	
Comment	Setup: 0	.00Hrs/ Run: 0.0000Min	Total Run :	0.0000Hrs		FOR THE PART OF TH
	Faire les	réparations de finition s	y a lieu a l'	aide du "Filler" P15-3.		
	Date: 2	10/1690eau: (3	10)	93/		
41.0 Comment	AAC1021	0 0000 UNUTE (-\# L-%		Dupont Primer N° 7704S	o/ oc	
Comment		0.0280 UNITE(s)/Unit Primer N° 7704S	Total: 0.8	0280 UNITE(s) 1-34195-2	2	
42.0	AAC1101			N° 7775S, Dupont Activator -	Red	uœr Chromabase
Comment		0.0283 UNITE(s)/Unit		0283 UNITE(s)	.)	-34636-5
43.0	PRIMER	S, Dupont Activator - Re		abase N° de Lot application primer	<u> </u>	- ,)4240
				,		
Comment	Setup: 0		Total Pun :	0 0000Hen		
	octup. o.	OOTHS/ INDII. O.OOOONIII	TOTAL NULL	0.0000nrs		premier primer:
	Faire la p	réparation et l'application	n du primer s	selon I.G. 0008	. 1	39.00.12 [-33195-3
	Date:	Sceau:	(3) # 0	le fiche de mélange: \	M	LOT ACTIVATOR
	NSPEC FINA		mandainen (** - : : : : : : : : : : : : : : : : : :	spection finale	7	1-33616-1
				ý		
Comment	Setup: 0.0	00Hrs/ Run: 0.0000Min	Total Run : (0.0000Hrs		TÁMANATAN WANA WANA AMA
	Coles View		N9 50145			•
	raile ins	pection selon le dessin l	N° D2445.			
	Date (e.S.					
45.0 E	MBAL / ENTI	REPO	Er	nballage & Entreposage		A PROPERTY OF THE LABOR
Comment	Setup: 0.0	0Hrs/ Run: 0.0000Min	Total Run : 0	0.0000Hrs		The state of the s
	Faire l'emi	pallage des pièces selo	JG 0057			
		G,	3			
	Date:	Sceau:	<u> </u>			

ICA-D350-588

ICA Page 33 (34 blank) of 34

52.3 WEIGHT AND BALANCE

Installation	Weight	LAT	ERAL	LONGITUDINAL		
		Arm	Moment	Arm	Moment	
D350-588-011	1.0 lb	-21.0 in	-21.0 in-lb	+170.0 in	+170.0 in-lb	
Aft Door Fwd Hinge Modification Kit	0.45 Kg	-0.53 m	-0.24 m-Kg	+4.32 m	+1.96 m-Kg	
D350-588-041*	2.0 lb	-21.0 in	-42.0 in-lb	+170.0 in	+340.0 in-lb	
Aft Door Assembly	0.91 Kg	-0.53 m	-0.48 m-Kg	+4.32 m	+3.93 m-Kg	

^{*} D350-588-041 Aft Door Assembly weight in excess of standard Eurocopter Door.

52.4 PARTS LISTS

Revision: 0

588 -,	588	Part Number	Description
₹0414	-011		
(Xノ		D350-588-041	AFT DOOR ASSEMBLY
	Χ	D350-588-011	AFT DOOR FWD HINGE MODIFICATION KIT
	1	D2143	HINGE DOUBLER
1	1	D2144	HINGE DOUBLER
C22	2	D2150	HINGE PACKER
~2 5	2	D2151	HINGE DOUBLER
7	1	D2153-3315-10	GAS SPRING ASSY.
(I)	1	D2154	STUD BRACKET
(-2 \)	2	D2237	STRIKER PLATE
611		D2445	DOOR
~1	1	D2461-0870	NEOPRENE D SEAL
21.5	1	D2463-0870	½" FOAM SEAL
	2	D2583	LATCH BRACKET
 2	2	D2585	LATCH CLAMP
2	2	D2586	LATCH
	1	D2587	PLUG
U 10	1	D2589	KEYS, KEY CHAIN
2>		D2621	LATCH PLATE
70	1	D2690-17	CABLE, DOOR STOP
EP	1	D2857-1	LOWER HINGE BRACKET
===	1	D2857-2	UPPER HINGE BRACKET
\$7.±1⊃	1	D2858-1	LOWER HINGE BRACKET
2	1	D2858-2	UPPER HINGE BRACKET
८ %⊃	8	AN526C832R8	SCREW (or AN526-832R8)
C 87	8	AN526C832R9	SCREW (or AN526-832R9)
22	2	AN526C1032R7	SCREW (or AN526-1032R7)
L24J	24	AN960JD8	WASHER -/6
¢ 4⊃	4	AN960JD10	WASHER
420	12	MS20426AD3-4	RIVET
7485	18	MS20470AD4-5	RIVET
	18	MS21042L08	NUT (or MS21042-08) - /∂
4.3	4	MS21042L3	NUT (or MS21042-3)
_2	2	MS27039-1-15	SCREW
2	2	MS27039-0811	SCREW
-1_	1	N/A	1 SQUARE ft. OF 9 oz. GLASS CLOTH (S-CLASS)
		L	

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